RENA

T-750

TABBER AND STAMP AFFIXER

SERVICE MANUAL

SAFETY PRECAUTIONS

THIS EQUIPMENT PRESENTS NO PROBLEM WHEN USED PROPERLY. HOWEVER, CERTAIN SAFETY RULES SHOULD BE OBSERVED WHEN OPERATING THE T-750 TABBER.

BEFORE USING THE TABBER, YOU SHOULD READ THIS MANUAL CAREFULLY AND FOLLOW THE RECOMMENDED PROCEDURES, SAFETY WARNINGS, AND INSTRUCTIONS:

- ✓ Keep hands, hair, and clothing clear of rollers and other moving parts.
- ✓ Avoid touching moving parts or materials while the machine is in use. Before clearing a jam, be sure machine mechanisms come to a stop.
- ✓ Always turn off the machine before making adjustments, cleaning the machine, or performing any maintenance covered in this manual.
- ✓ Use the power cord supplied with the machine and plug it into a properly grounded wall outlet located near the machine and easily accessible. Failure to properly ground the machine can result in sever personal injury and/or fire.
- ✓ The power cord and wall plug is the primary means of disconnecting the machine for the power supply.
- ✓ DO NOT use an adapter plug on the line cord or wall outlet.
- ✓ DO NOT remove the ground pin from the line cord.
- ✓ DO NOT route the power cord over sharp edges or trapped between furniture.
- ✓ Avoid using wall outlets that are controlled by wall switches, or shared with other equipment.
- ✓ Make sure there is no strain on the power cord caused by jamming between the equipment, walls or furniture.
- ✓ DO NOT remove covers. Covers enclose hazardous parts that should only be accessed by a qualified service representative. Report any damage of covers to your service representative.
- ✓ This machine requires periodic maintenance. Contact your authorized service representative for required service schedules.
- ✓ Use this equipment only for its intended purpose.

In addition, follow any specific occupational safety and health standards for your workplace or area.

This manual is intended solely for the use and information of RENA Systems, Inc., its designated agents, customers, and their employees. The information in this guide was obtained from several different sources that are deemed reliable by all industry standards. To the best of our knowledge, that information is accurate in all respects. However, neither RENA Systems, Inc. nor any of its agents or employees shall be responsible for any inaccuracies contained herein.

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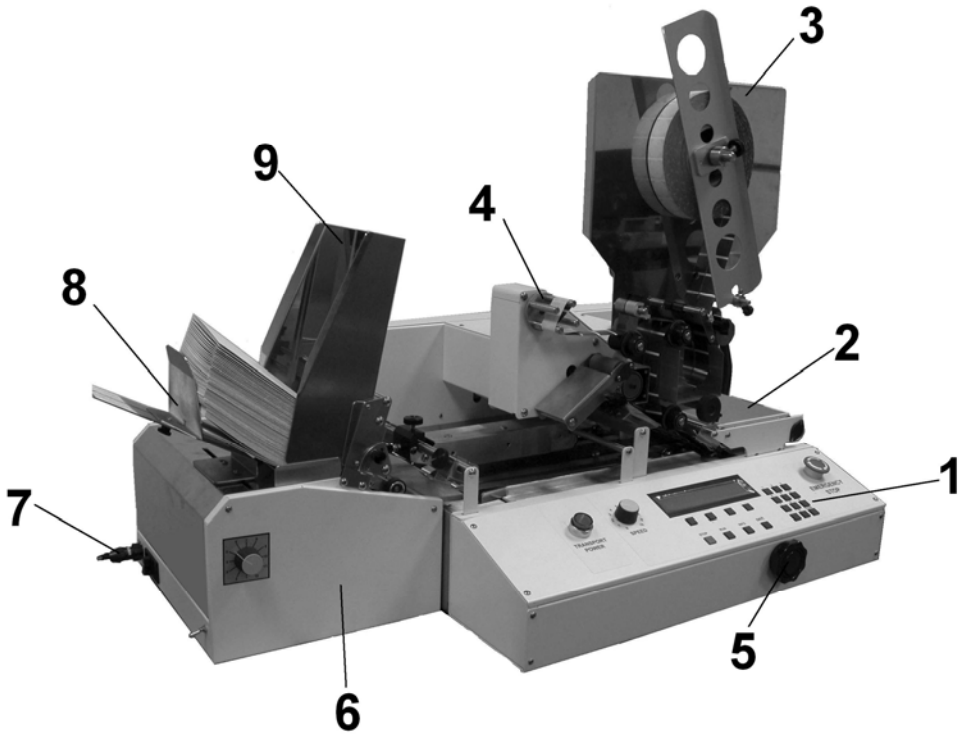
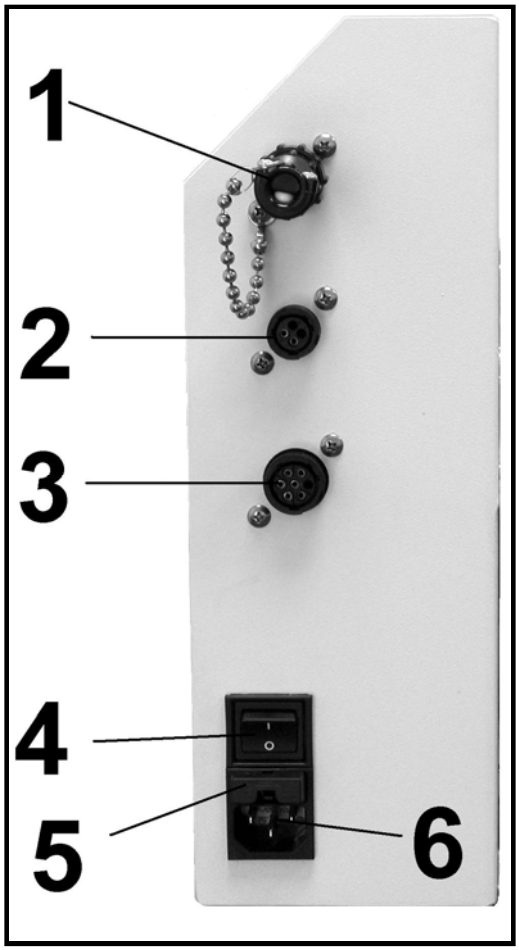
Section 1 – Getting Acquainted

Front View



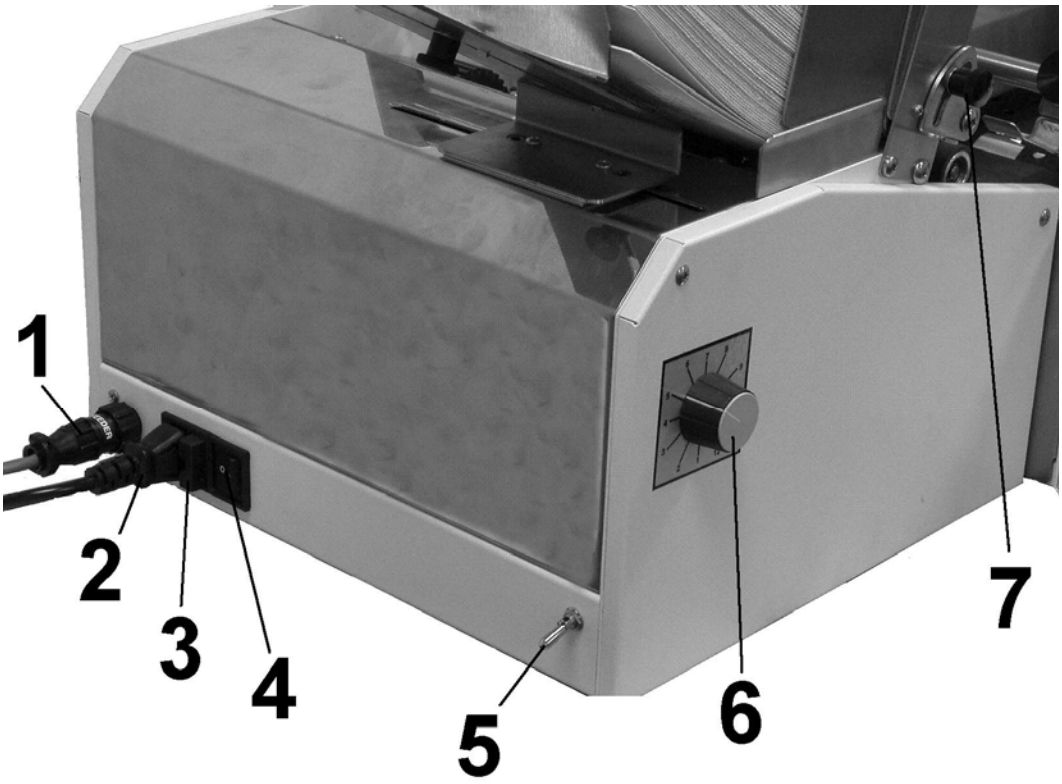
1	**Control Panel** – The machine is controlled and programmed from this panel.
2	**Pressure Roller Assembly** – This assembly presses the tab to the media.
3	**Reel** – The tabs or stamps are loaded on this reel assembly.
4	**Take-up Reel** – The tab web is wound up here after the tab is applied.
5	**Media Height Adjustment Knob** – This knob permits the operator to raise or lower the head assembly to adjust fro the thickness of the media. .
6	**Feeder Assembly** – The Feeder is used to feed media to the Tabber.
7	**Feeder Interface Cable** – This cable when connected to the tabber permits the tabber to control the feeder.
8	**Media Support** – Supports the media while it is being fed.
9	**Media Guides** – Help hold the media in place while it is being fed.
10	**Media Thickness Adjustment** – The crank permits the operator to raise or lower the head assembly to adjust for the thickness of the media.

Tabber Rear View



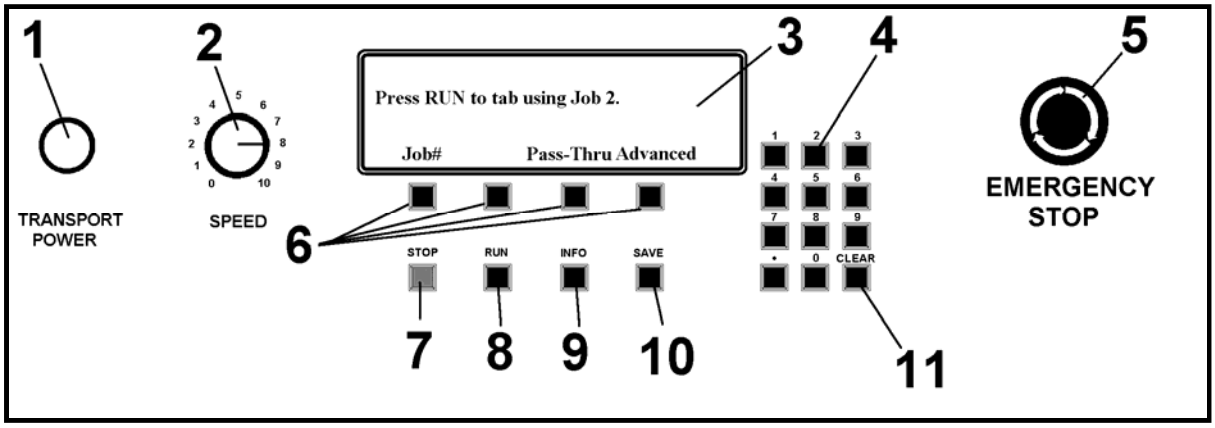
1	**Emergency Stop Input** – This connector when wired into an existing safety circuit permits an emergency stop on from the existing circuit to stop the T-750. The jumper plug is required when this feature is not used.
2	**Emergency Stop Output** –This connector permits the T-750 to control the emergency stopping of another machine.
3	**Tabber/Feeder Control Cable** – The feeder is connected here to permit automatic operation of the feeder when used with the T-750.
4	**Main Power Switch** – This switch turns the T-750 On and Off.
5	**Fuse** – The main power fuse for the T-750 is located here.
6	**Power Inlet Connection** – The power cord is plugged in here.

Feeder Connections



1	**Tabber/Feeder Control Cable** – This connection permits the tabber to control the feeder when the mode switch is in the Automatic Position.
2	**Power Inlet Connection** – The power cord is plugged in here.
3	**Fuse** – The feeder fuse is located here.
4	**Main Power Switch** – This switch will turn the feeder On and Off.
5	**Mode Switch** – The mode switch permits selection of either the Automatic Mode (the tabber controls the Feeder) or Manual Mode (the feeder speed is controlled manually by the Feeder Speed Control).
6	**Feeder Speed Control** – When the feeder mode switch is in the manual position, this knob controls the speed of the feeder.
7	**Media Thickness Adjustment –** Loosening the knob and repositioning the lever is used for adjusting the exit rollers of the feeder for thicker media.

Tabber Control Panel



1.	**TRANSPORT POWER SWITCH** – Turns the T-750 transport power ON.
2.	**SPEED CONTROL** – Adjusts the speed of the T-750. **NOTE: The maximum speed of the T-750 tabber is controlled by the software. The speed of the tabber for applying single tabs is 20,000 pieces per hour, for applying double tabs it is 12,000 pieces per hour and for applying triple tabs it is 8, 000 pieces per hour. Exceeding these speeds will cause the tabber to stop.**
3.	**LCD DISPLAY** – Keeps the operator informed of the status of the T-750.
4.	**KEY PAD** – Used to set the adjustments and program the T-750
5.	**EMERGENCY STOP –** When the T-750 is properly connected to the feeder and/or other pieces of equipment activating this button will stop the machines.
6.	**SOFT KEYS** – The soft keys are used to step through the various menu options to program the T-750.
7.	**STOP KEY** – Pressing this key will stop the T-750 and hold it in a ready state to resume operation.
8.	**RUN KEY** – Pressing this key to start the T-750 when running a job.
9.	**INFO KEY** – Pressing this key will change the display to the information mode.
10.	**SAVE KEY** – This key is used to save the entries into the memory.
11.	**CLEAR KEY** – This key will clear any incorrect entry before it is saved in the memory.

–

SECTION 2 - *Assembly and Installation*

The T-750 is shipped in a single carton.

Assembly

Choose a Location

Place the T-750 with its feeder on a sturdy worktable or cabinet at least 12 inches from any walls. Allow enough room to place the Feeder on the same work surface. Protect the T-750 from excessive heat, dust, and moisture – avoid placing it in direct sunlight.

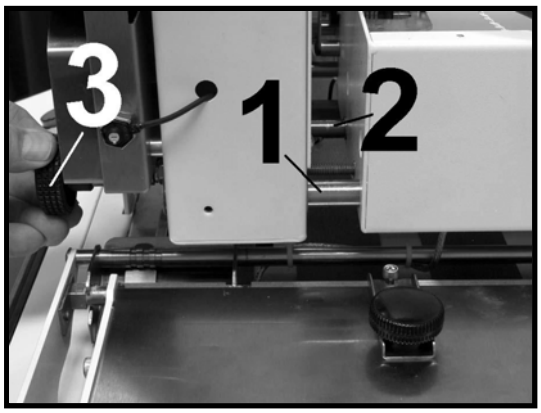
CAUTION

THE UNIT IS HEAVY.
IT IS STRONGLY RECOMMENDED THAT TWO TECHNICIANS REMOVE THE TABBER FROM THE CARTON AND PLACE IT ON THE WORKING SURFACE.

Install Reel Assembly

Once the main body is placed, the next step is to install the Reel Assembly.

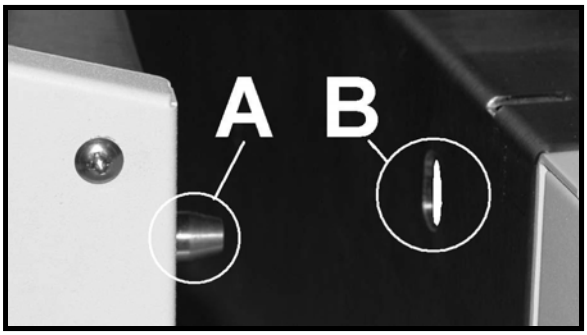
1. Place the reel assembly over the Guide Pin [1]. Make sure that the head is over Guide Pin [2] while you are tightening the Fine Adjustment Knob [3] clockwise.



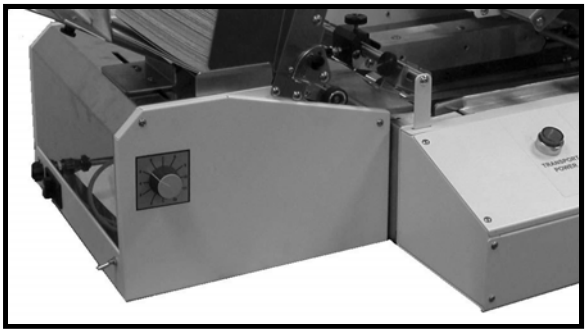
2. When the Reel assembly is completely seated, plug in the reel assembly power cord.

Install the Feeder

1. The pin [A] on the feeder should mate with the hole [B] on the Tabber body.



2. When the feeder is properly aligned with the tabber body it will appear as in this picture.

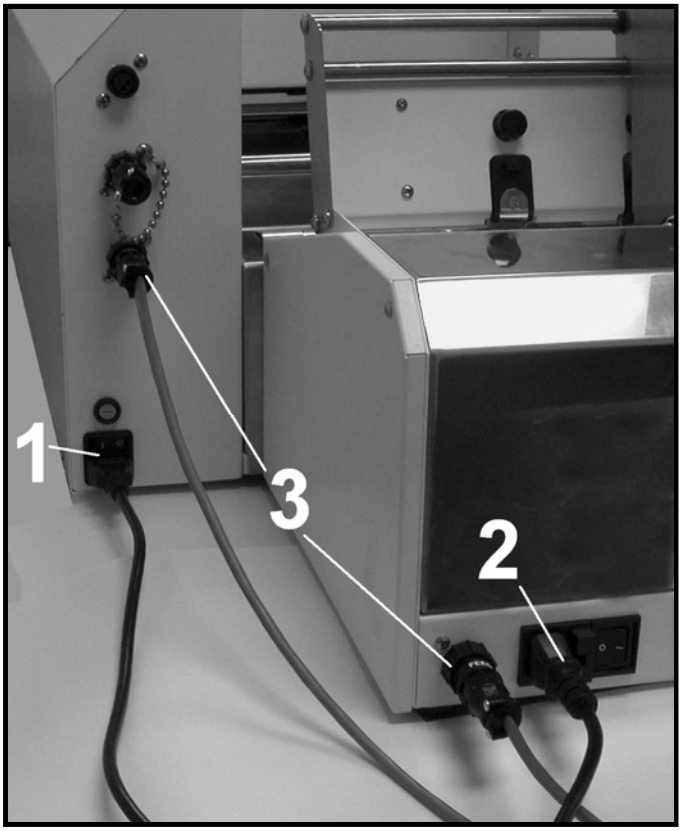


Installation

Plugging in the Feeder and Tabber

Make sure that the emergency stop switch of the T-750 is in the OFF position and the main power switch above the power cord receptacle is in the OFF position. Make sure that the power switch on the feeder is in the OFF position also.

1. Connect one end of the Tabber power cord [1] to the rear of the T-750 in the corresponding receptacle.
2. Connect one end of the Feeder power cord [2] to the rear of the Feeder in the corresponding receptacle.
3. Plug the other end each cord into a 115-220 Volt AC, 50/60 Hz. Grounded outlet.



CAUTION

DO NOT USE ADAPTER PLUGS OR EXTENSION CORDS TO CONNECT THE TABBER OR THE FEEDER TO THE WALL RECEPTACLE.
DO NOT USE OUTLETS CONTROLLED BY WALL SWITCHES.

DO NOT USE AN OUTLET THAT SHARES THE SAME CIRCUIT WITH LARGE ELECTRICAL MACHINES OR APPLIANCES.

4. Connect the Feeder Interface cable [3] to the Feeder and to the lower connector on the Tabber.

Notes

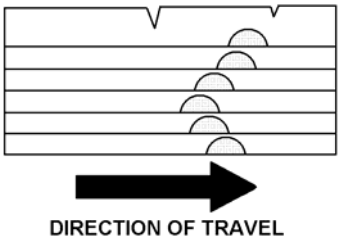
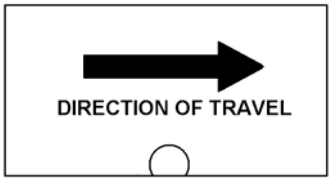
SECTION 3 – Troubleshooting

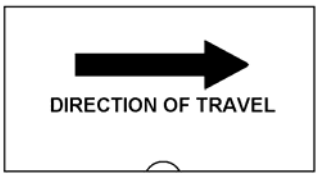
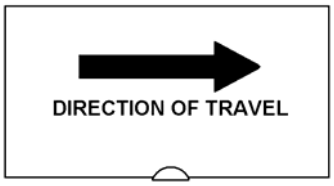
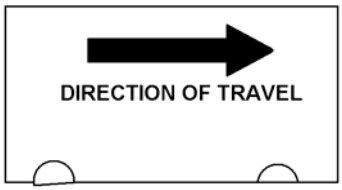
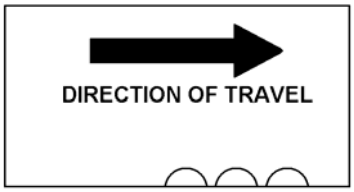
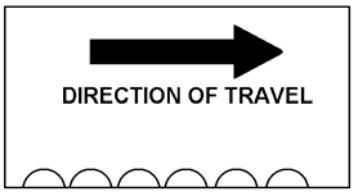
The following trouble-shooting guide is provided to assist you in solving any problems that might occur with the T-750 Tabber. We have tried to make it as complete as possible. The best advice we can offer is to make sure that the tabs, labels or stamps are threaded properly and that the machine is plugged in and turned on.

Jams

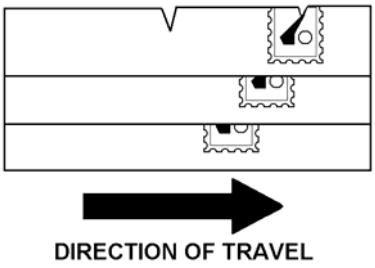
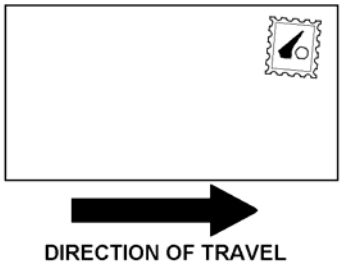
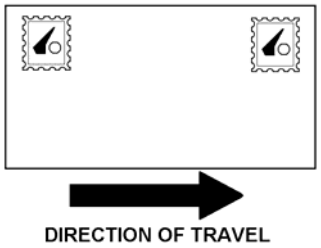
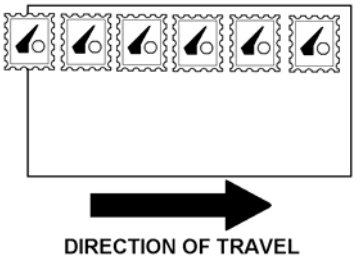
CONDITION	SOLUTION
Media jams in transport section of Tabber.	1. Check alignment of Feeder to Tabber. Media should be feed between 1/8" to 1/32" from the fixed guide in the tabber. 2. Check that the two paper guides are not pressing down too firmly on the media. 3. Check that the adjustable center guide is not pushing the paper tightly against the fixed side guide 4. Check that the head pressure is not too tight.

Tab Placement Problems

CONDITION	SOLUTION
Tabs are not placed in the same spot on the media.  	Tabs should be placed within +/- 1/8" 1. Check the pitch setting for the tab. It should be slightly more than the tab size plus the space between the tabs. 2. Check the amount of head pressure. Too little can cause the media to slip when it is being fed. 3. Check that the pointer on the applicator head is in the center of the tab.
More of the tab is on the top of the media than on the bottom.  	Adjust the fine adjustment knob (Page 12) clockwise to move more of the tab to the bottom side of the media.

CONDITION	SOLUTION
Less of the tab is on the top of the media than on the bottom. 	Adjust the fine adjustment knob (Page 12) counterclockwise to place more of the tab to the top side of the media.
Tab is not flush with the edge of the media. 	Media is not being fed flush with the fixed side guide. There should not be more than 1/8" to 1/32" space between the media and the fixed side guide when the media enters the tabber.
When double tabbing one tab is not placed properly on the edge of the media. 	1. The media may not be traveling along the fixed side guide. Adjust the angle of the guide rollers by turning the knob on the skew guide. 2. Check the pressure between the head and the transport. Too much pressure will cause the media to flex as it is transported. 3. Too little pressure can cause the media to skew as the tab is being applied.
Two or three tabs applied next to each other. 	Programming issue. When programming the multiple tabs **Together** was selected instead of **Separate**. Reprogram the job.
More than three tabs applied on each piece. 	Tab sensor adjustment improper. Check Tab Voltage and Backing Voltage adjustments. (Page 21)

Stamp Placement Problems

CONDITION	SOLUTION
Stamps are not placed in the same place on the media.  	Stamp placement should be within +/- 1/8” 1. Check the pitch setting for the stamp. It should be slightly more than the stamp size plus the space between the stamps. 2. Check the amount of head pressure. Too little can cause the media to slip when it is being fed.
When applied the Stamp is not aligned on the media.  	1. The media may not be traveling along the fixed side guide. Adjust the angle of the guide rollers by turning the knob on the skew guide. 2. Check the pressure between the head and the transport. Too much pressure will cause the media to flex as it is transported.
Two or three stamps applied evenly spaced.  	Programming issue. When programming multiple stamps **Separate** was selected instead of **Together**. Reprogram the job.
More than three stamps applied one after another on the media when 1, 2 or 3 stamps are selected.  	Tab (Stamp) sensor adjustment improper. Check Tab Voltage and Backing Voltage adjustments. (Page 21)

Tabber Operation Problems

CONDITION	SOLUTION
Tab web breaking at the Unwind Driver Roller.	Clean tab unwind roller.
Tabber Stops while tabbing.	1. Speed of tabbing exceeds maximum speed for the number of tabs being applied. Slow down tabber. 2. Feeder speed is too fast, leaving too little gap between pieces. Slow down feeder.

Feeder Problems

CONDITION	SOLUTION
Feeding double sheets.	Adjust sheet separators. For material thicker that a single sheet folded in half, use the piece plus one sheet of paper when adjusting the separators.
Failure to feed media.	1. Sheet separators set too tight. Clean feed rollers or replace as required.

SECTION 4 – Adjustments

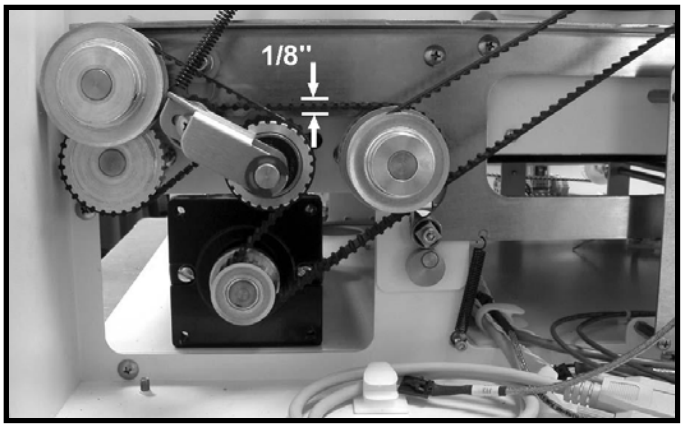
Motor Drive Belt

Requirement:

The motor drive belt must have the proper tension.

Adjustment:

1. Unplug the machine from its power source.
2. Remove Reel assembly from the machine.
3. Remove the five screws and remove the rear cover.
4. Remove the cover from the right-hand side of the machine.
5. Lay the Tabber on its back frame.
6. Loosen the four Allen head screws that attach the motor to its base.
7. Slide the motor toward the exit of the machine and tighten the screws [1].
8. Check for 1/8” play in the belt.
9. Replace the covers, reel assembly and reconnect the cables.



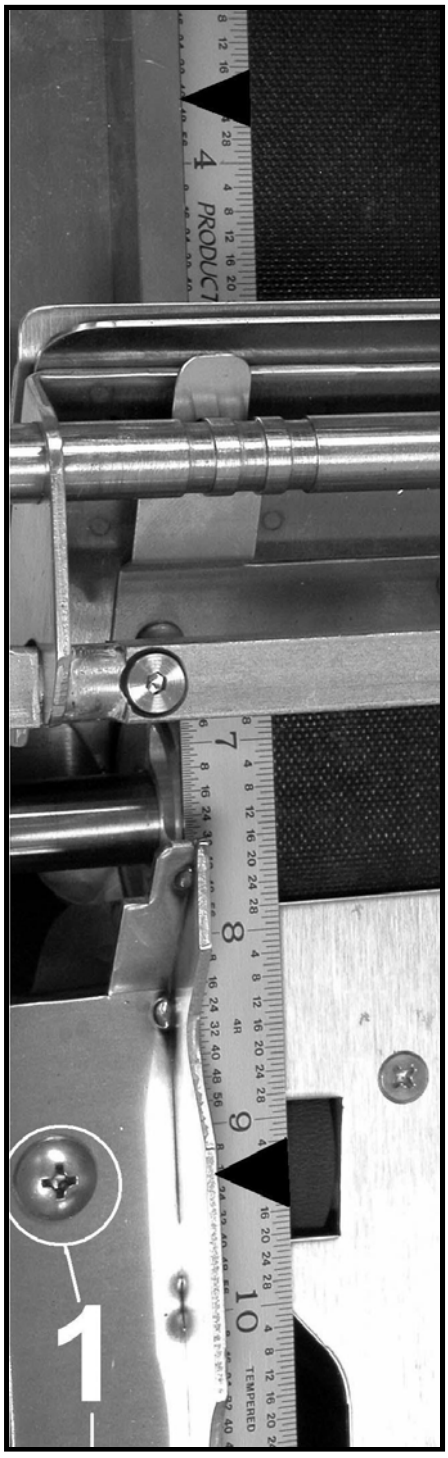
Tab Guide Alignment

Requirement:

The tab guide must be in alignment with the media guide.

Adjustment:

1. Remove the Tab Reel Assembly and open the roller cover.
2. Place a straight edge against the long media guide.
3. Loosen the two Adjustment Screws [1] holding the tab guide in place and adjust the tab guide so that it just touches the straight edge.
4. Tighten the two screws.
5. Replace the Tab Reel Assembly.



Tab Guide Plate Adjustment

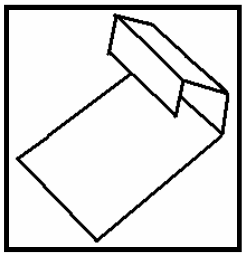
Requirement:

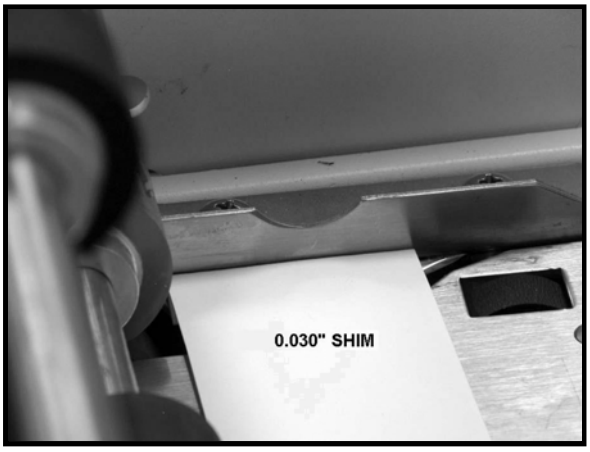
The tab guide roller must contact the tab guide plate for proper tab sealing. Before adjusting check the Head Assembly Alignment adjustment is correct and that the **head assembly** is in its **lowest position**.

Adjustment:

1. Turn off the Tabber.
2. Remove the Tab Exit cover.
3. Open the Media Exit assembly and place a 0.030" shim on the tab fold plate.

NOTE: The shim goes against the tab fold plate and is equal to a piece of 70 lb. index stock folded four times.





4. Remove the screw [1] and apply Blue #242 Loctite to its threads, then replace the screw.
5. Close the Media Exit Guide, then press down on the Tab Guide Roller bracket [2] and the Media Exit Assembly [3], and then tighten the screw [1].
6. Replace the Tab Exit cover.

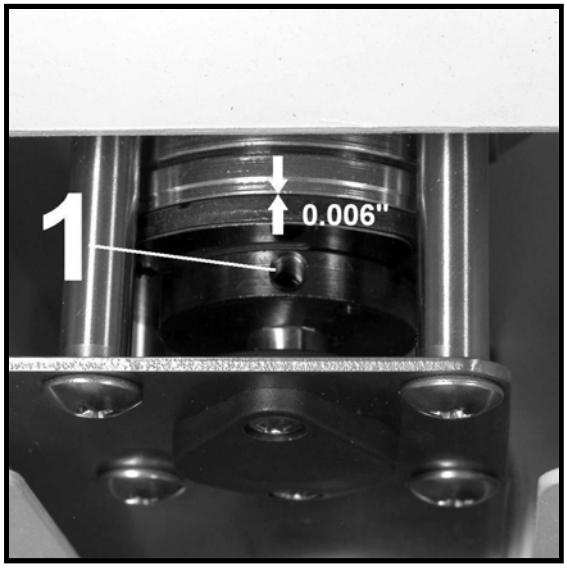
Reel Brake Adjustment

Requirement:

The Reel Brake must be set properly to stop the reel from coasting.

Adjustment:

1. Remove the Brake Cover from the Head assembly.
2. Loosen the two Allen screws [1] on the Brake plate. Position the Brake Plate 0.006 inches from the Brake body and tighten the screws.



3. Replace the Brake Cover on the Head assembly.

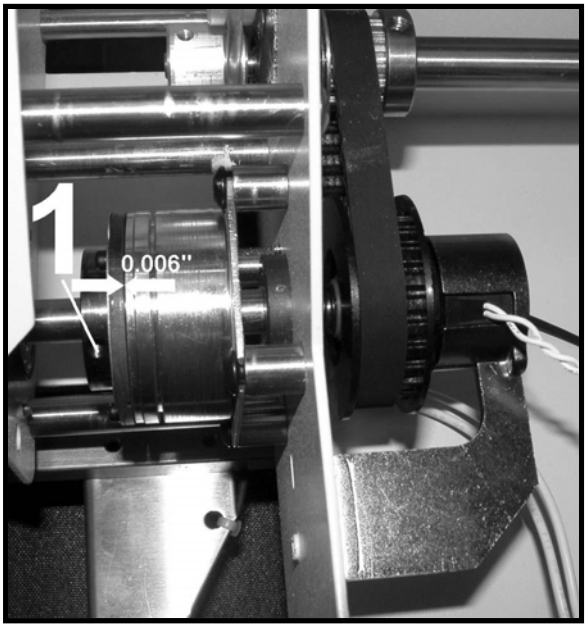
Tab Clutch and Brake Adjustment

Requirement:

The Tab Brake must be set properly to advance the tabs.

Adjustment:

1. Remove the Reel Brake Cover and the Top cover from the unit.
2. Loosen the two Allen screws [1] that hold the brake plate to the shaft.
3. Insert a 0.006” feeler gage between the brake and the brake plate.
4. Tighten the two Allen screws [1].
5. Replace the covers.



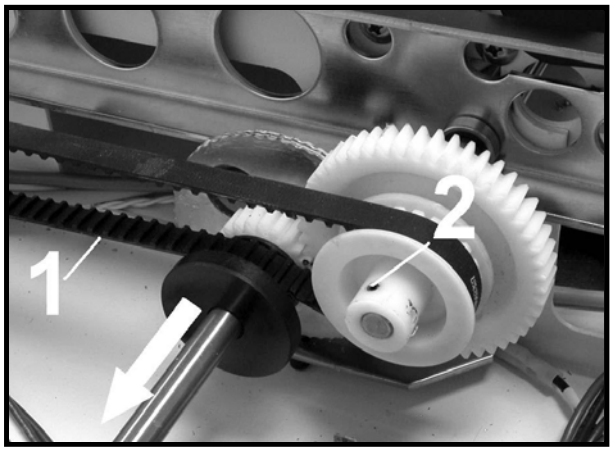
Head Assembly Alignment

Requirement:

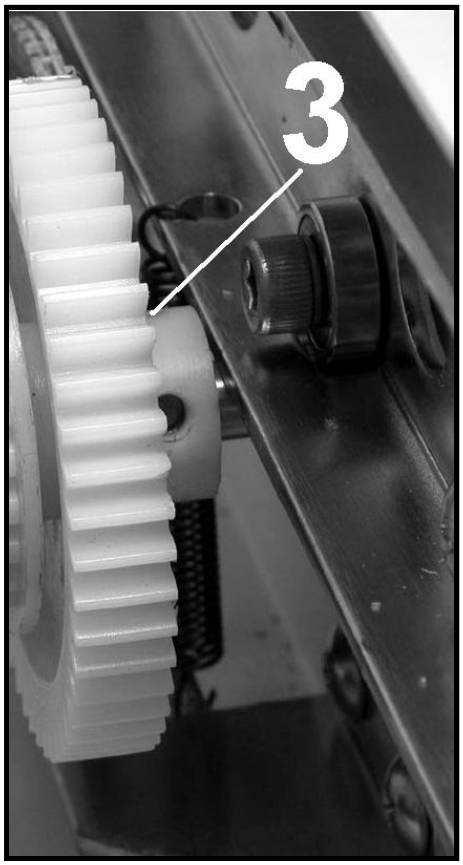
The Head Assembly must ride evenly on the head raise cams.

Adjustment:

1. Remove the front and rear covers.
2. Slide the belt take-up pulley away from the head raise belt [1] by lifting the belt and sliding the pulley away from it.
3. Remove the Allen screw in the head raise pulley [2] and remove the gear and belt.



4. Remove the Allen screw attaching the head raise gear [3] to the right-hand head raise shaft.



5. Turn the Media Height Adjusting Knob fully counterclockwise until it touches its stop pin.
6. With the four tension springs in place, turn the two cam shafts counterclockwise until they just touch the bearings.

NOTE: The view shown is of the rear cam on the left-hand side.

7. Replace the head raise gear and tighten the Allen screw.
8. Replace the head raise pulley and tighten the Allen screw.
9. Replace the belt and belt tensioner.

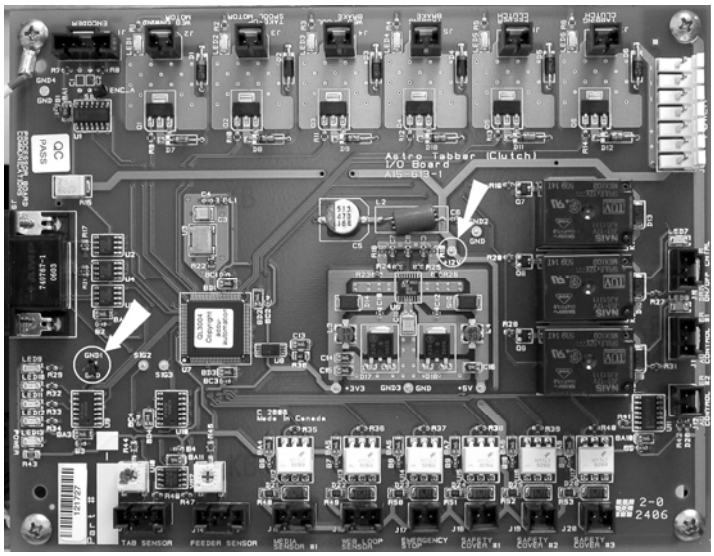
Power Supply Adjustment

Requirement:

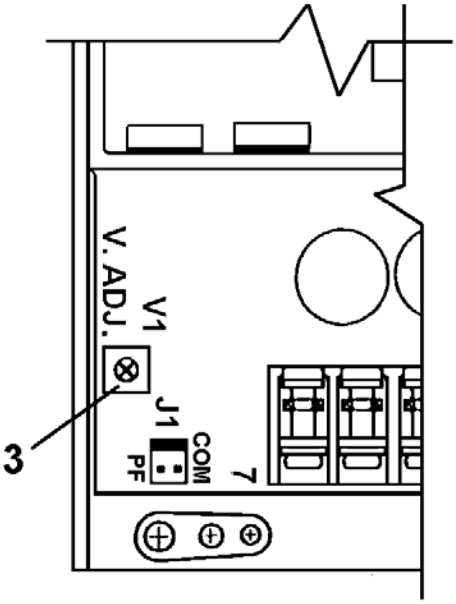
Provide proper output from power supply to machine.

Adjustment

1. Remove rear cover and connect voltmeter probe to GND [1] and +12V [2] on Interface PC Board. Turn the tabber **ON**.
2. Adjust V1 ADJ potentiometer [3] on the Power Supply module to obtain 12.0 VDC ± 0.1 V.
3. Turn the tabber **OFF**, apply lacquer such as nail polish to the potentiometer, and replace the cover.



INTERFACE PC BOARD



POWER SUPPLY MODULE

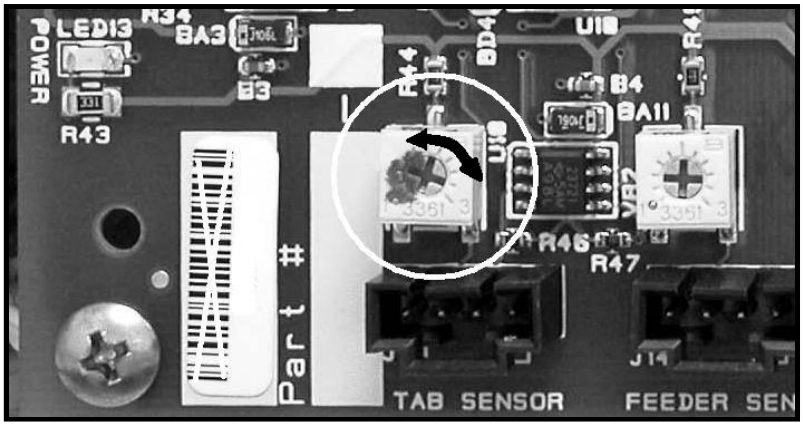
Tab Sensor Adjustment

Requirement:

Adjust the Tab Sensor so that it can automatically detect the tabs in the machine.

Adjustment:

1. Remove the rear cover from the tabber.
2. Locate the Tab Sensor potentiometer on the I/O PC Board. (Lower left-hand corner)
3. Turn the Potentiometer on the I/O PC Board all the way clockwise, then back ½ turn.
4. Replace the rear cover on the tabber.



INTERFACE PC BOARD

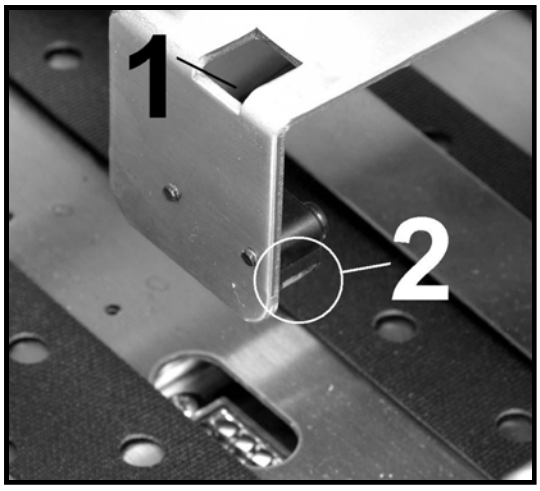
Media Sensor Adjustment

Requirement:

Adjust the Media Sensors so that they detect the media.

Adjustment:

1. Turn the tabber on with the main power switch.
2. Place a piece of white paper or card stock on the belts so that it blocks the reflective lens mounted on the base of the tabber. Adjust the sensor as follows.
3. Turn the sensitivity adjustment [1] fully counterclockwise to the minimum sensitivity position.
4. Place a piece of media between the sensor and the reflector, adjust the sensitivity adjustment clockwise until the *GREEN* light [2] is lit, then back off the adjustment slightly.
5. Remove the piece of media. Both the *GREEN* and *ORANGE* lights should light.
6. Place a small amount of lacquer or nail polish on the adjustment.



MEDIA SENSOR

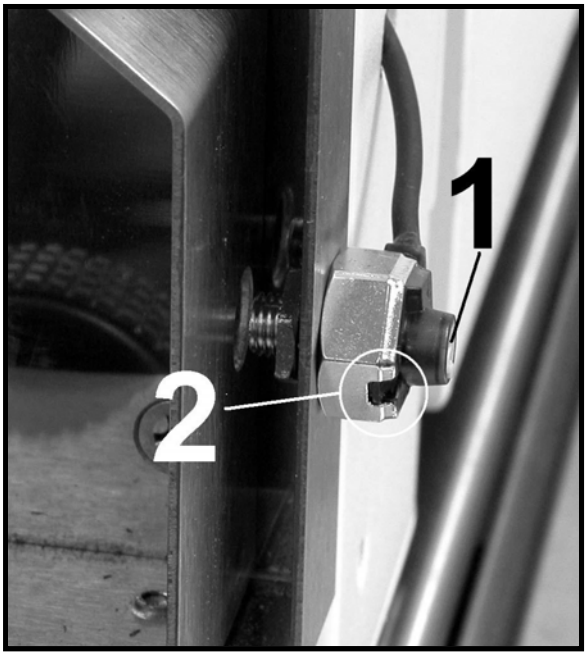
Tab Web Sensor Adjustment

Requirement:

Ensure that tabs are fed in time to be applied to the media.

Adjustment:

1. Turn the tabber on with the main power switch.
2. Place a piece of white paper or card stock in the tab bin on the side where the non-reflective (black) surface is, then adjust the sensor as follows.
3. Turn the sensitivity adjustment [1] fully counterclockwise to the minimum sensitivity position.
4. With a piece of white media in the bin, adjust the sensitivity adjustment clockwise until the *GREEN* light [2] is fully lit, then back off the adjustment slightly.
5. Remove the piece of media. Both the *GREEN* and *ORANGE* lights should be on.
6. Load a reel of tabs on the tabber and turn on the Head Power switch. The Unwind Drive roller should start running and feed tabs until the tab loop forms and blocks the sensor. At this point the *ORANGE* light should go out and the motor should stop.
7. Test run the machine and check to see that the sensor does not permit the web to be higher than 1.250” from the bottom of the BIN.
8. Place a small amount of lacquer or nail polish on the adjustment.



TAB WEB SENSOR

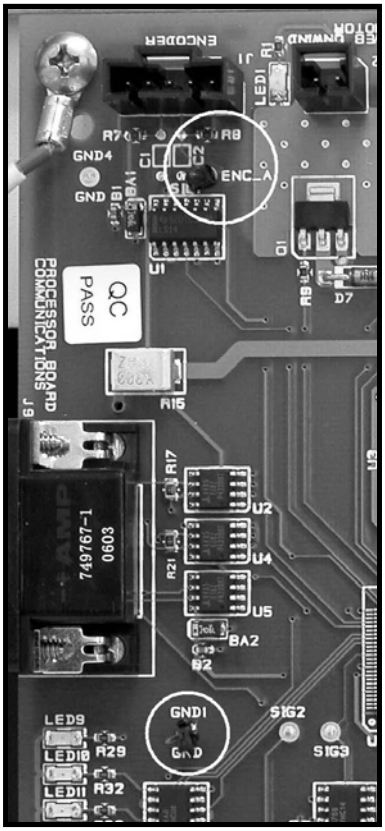
Tabber and Feeder Speed Control Adjustment – Part 1

Requirement:

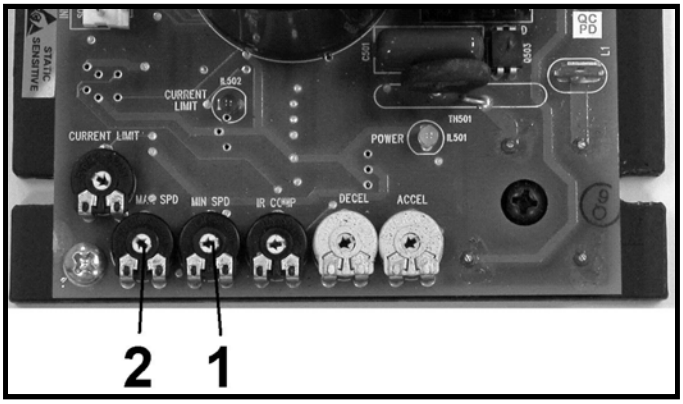
The maximum speed must be no more than 100 ips.

Adjustment:

1. Open the operator side cover. The speed control is located on the right-hand side.
2. Turn on the Tabber and turn on the Transport Power.
3. Adjust the Motor Speed Control knob on the control panel to “0”. The belts should not be moving at this point. If they are adjust the Min Speed potentiometer [1] on the Motor Control PC Board so that the belts do not turn.
4. Turn the Motor Speed Control knob to position “1”. The belts should be moving at slow speed.
5. Turn the Motor Speed Control knob to position “10”. The belts should be moving at a speed of 280 feet per second as measured with a tachometer. This is equivalent to a 28.3 KHz signal on the I/O PC Board at GND1 and ENC_A. Adjust the Max Speed potentiometer [2] on the Speed Control PCB.



INTERFACE PC BOARD



MOTOR SPEED CONTROL PCB

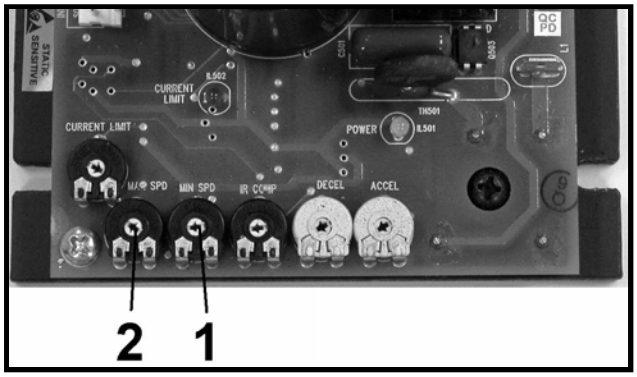
Tabber and Feeder Speed Control Adjustment – Part 2

Requirement:

The maximum speed must be less than the speed of the Tabber when it is operating in the Auto Mode.

Adjustment:

1. Remove the operator side covers. The speed control is located on the base of the machine. Set the Auto/Manual Switch on the Feeder to the **Manual** position.
2. Turn on the Feeder power switch.
3. Adjust the Motor Speed Control knob on the control panel to "0". The rollers should not be moving at this point. If they are adjust the Min Speed potentiometer [1] on the Motor Control PC Board so that the belts do not turn.
4. Turn the Motor Speed Control knob to position "1". The rollers should be moving at slow speed.
5. Set the Auto/Manual Switch to **Auto** and feed some media with the tabber speed control set at maximum. Adjust the Max Speed pot [2] on the feeder so that there is a 2" gap between the pieces being fed.
6. Turn off the machines and replace the covers.



MOTOR SPEED CONTROL PCB

Notes

SECTION 5 – Disassembly and Assembly

The following will assist you in disassembling the T-750 for servicing:

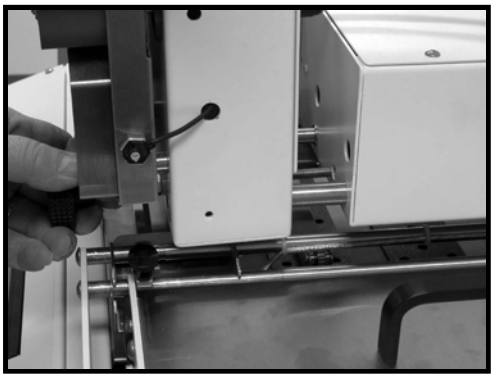
Tabber Disassembly

Removing the Reel Assembly

1. Disconnect the Reel Assembly power plug.

2. Turn the Reel Positioning Knob counterclockwise while supporting the assembly. Continue to turn the knob until the reel assembly comes free from the machine. Remove the reel assembly and set aside.

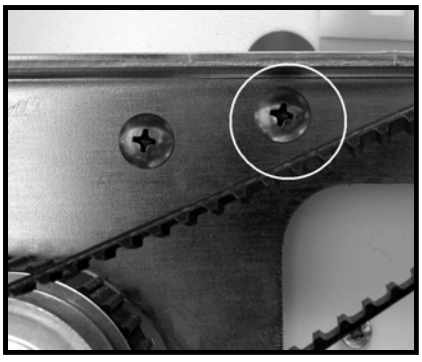
NOTE: The head assembly is supported on two shafts attached to the head assembly.



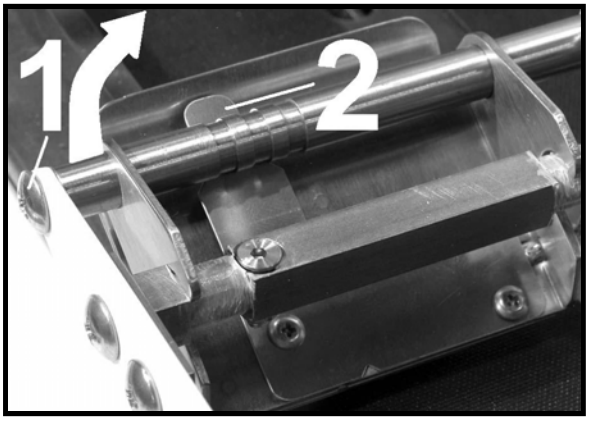
3. Reassemble in reverse order.

Removing the Applicator Head

1. Remove the reel assembly and Rear cover from the Tabber.
2. Loosen, but do not remove the Applicator Head support rod screw from the rear of the tabber.

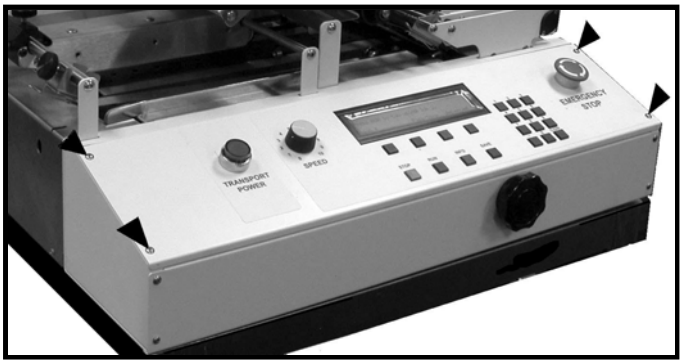


3. Remove the Applicator Head rod screw [1] and swing the rod away from the frame. Press on the Applicator Head release lever [2] and slide the Applicator Head assembly off the rod.

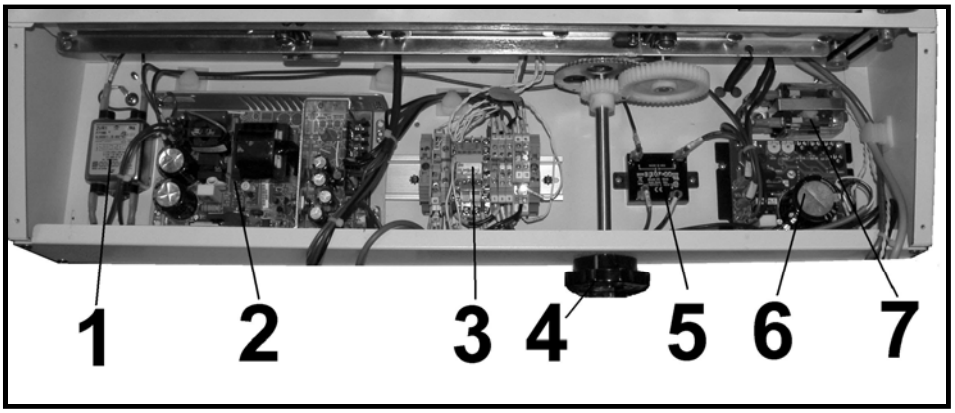


Removing Front Cover

1. Remove the four screws from the Front Cover; hinge the cover forward to gain access.

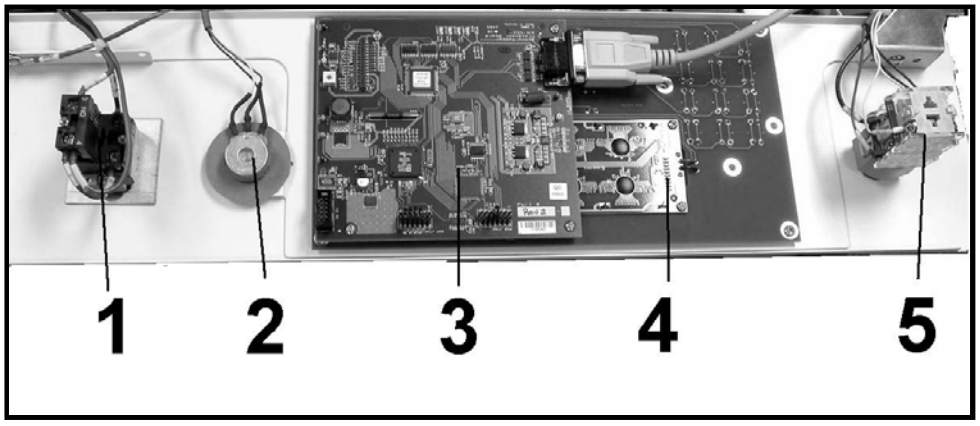


2. Components under Front Cover:



1. Line Filter
2. Power Supply.
3. Transport Power Relay.
4. Media Thickness Adjustment Knob.
5. Motor Speed Control Relay.
6. Motor Speed Control.
7. Motor Relay.

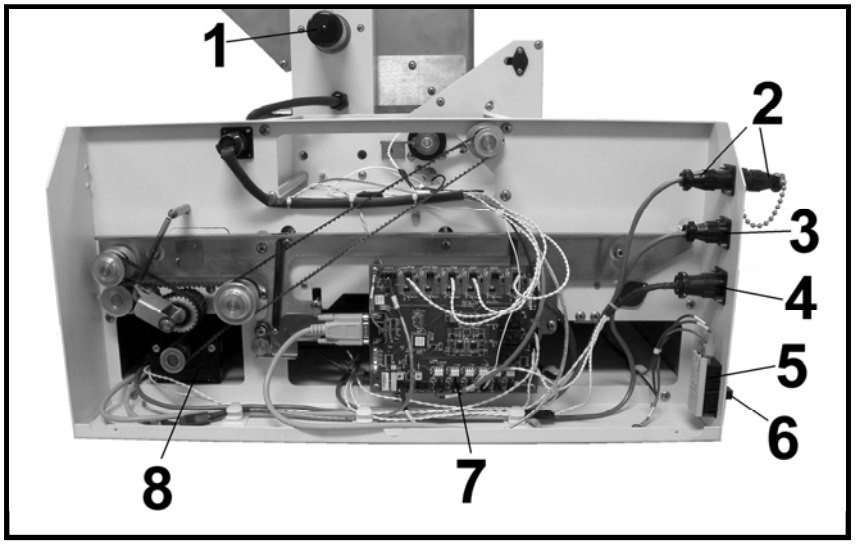
3. Components inside front cover.



1. Transport Power Switch
2. Transport Speed Control
3. Main Processor PC Board
4. Control PC Board and Display
5. Emergency Stop Switch

Removing Rear Cover

1. Disconnect the cables attached to the rear cover and remove the four screws.
2. Lift the cover from the tabber and allow it to hang.
3. Components under rear cover:



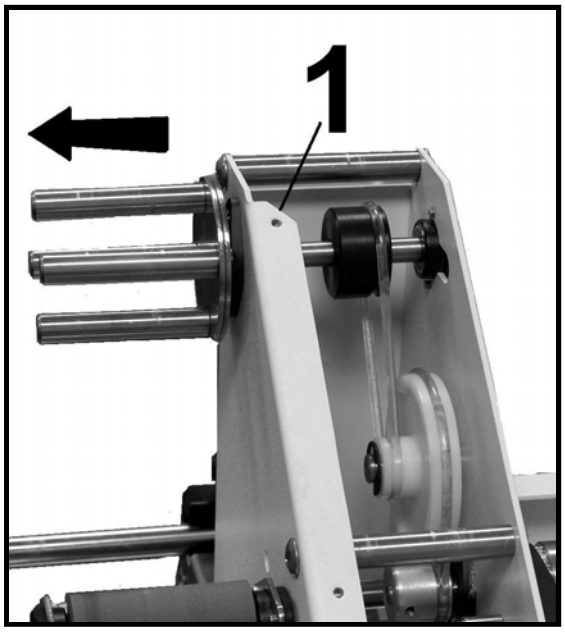
1. Tab Reel Drive Motor.
2. Emergency Stop Input
3. Emergency Stop Output
4. Feeder Interface Connector
5. Power Receptacle and ON/OFF Switch
6. Main Fuse
7. Interface PC Board
8. Main Drive Motor

Encoder and Encoder Drive Belt

1. The Encoder and Encoder Drive Belt are located under the front cover panel on the right-hand side of the tabber body.
2. To remove the Encoder or replace the Encoder Drive belt remove the two screws [1] that mount the encoder to the frame.
3. Reassemble in reverse order.

Replace the Take-up Reel Drive Belts

1. Remove the cover over the Take-up Reel drive assembly.
2. Remove the e-ring [1] from the Take-up Reel shaft.
3. Slide the assembly in the direction of the arrow and remove the belt.
4. To replace the drive belt, first remove the Take-up Reel drive belt, the remove the drive belt.

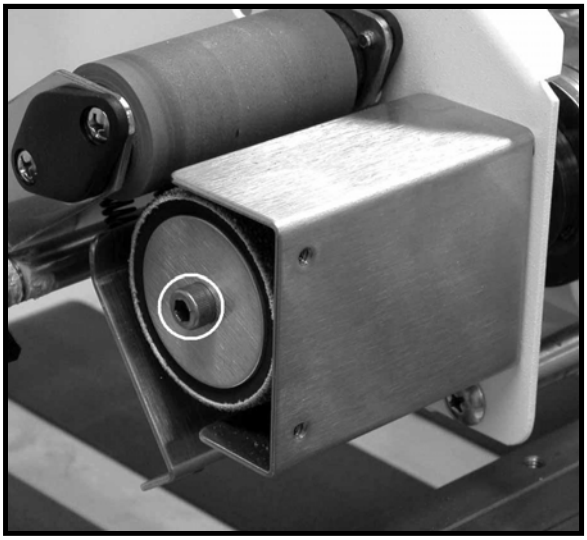


Replacing the Drive Motor

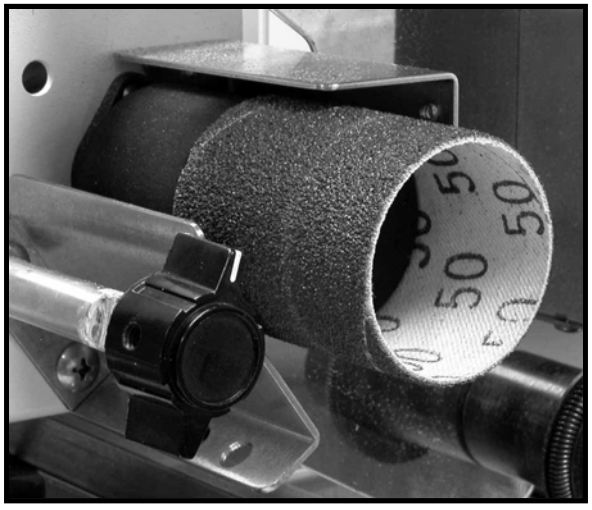
1. Remover the Reel assembly from the machine
2. Remove the rear cover from the machine.
3. Remove the cover from the right-hand side of the machine.
4. Lay the machine on its back and remove the four screws that mount the motor to the base.
5. Unplug and remove the motor.
6. Reassemble in reverse order.

Replacing Sandpaper Tab Drive Roller

1. Remove the cover over the tab drive roller.
2. Turn the Tabber on and set the speed control to “0”. Press the start button to cause the brake to activate. This will lock the drive roller so that the Allen screw can be removed.



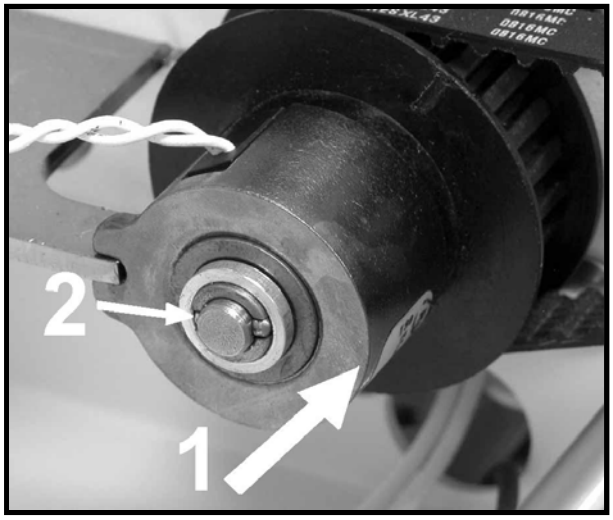
3. Remove the Allen screw that attaches the tab driver roller to the drive shaft and remove the roller.



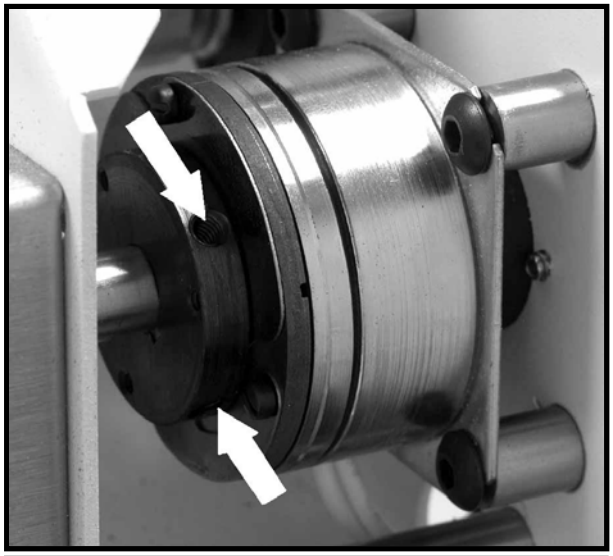
4. Repeat the steps in reverse after replacing the sand paper roller. Tighten the Allen screw to compress the rubber roller and hold the sandpaper roller in place.

Replacing Clutch and Brake

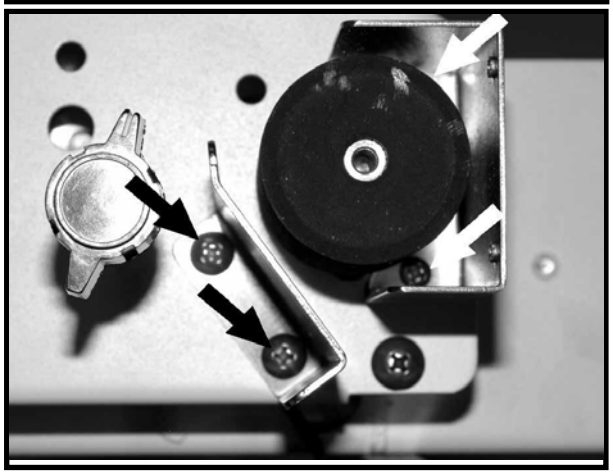
1. Remove the cover over the take-up reel and the top cover from the unit.
2. To remove the clutch press the clutch body toward the pulley [1] and remove the pin [2]. The clutch can then be removed.



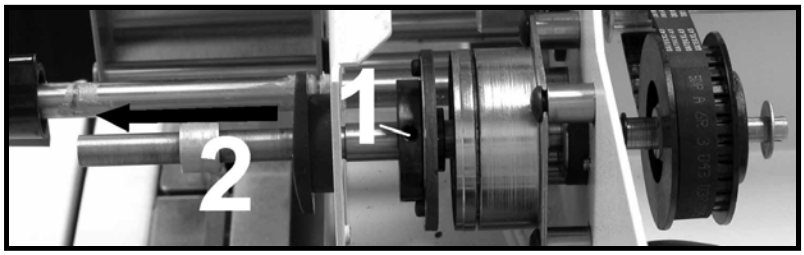
3. To remove the brake continue by loosening the two Allen set screws that attach the brake plate to the shaft.



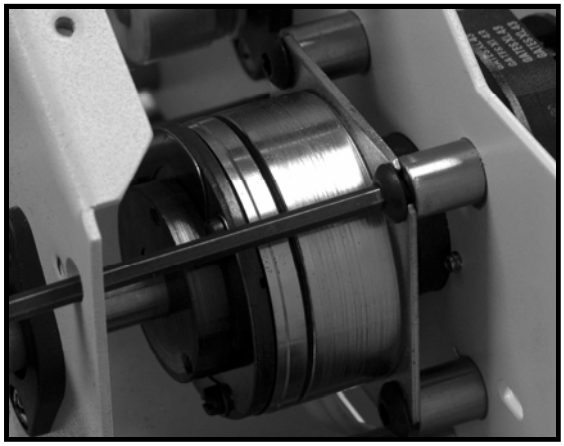
4. Remove the two shields from the frame.



5. In the following order remove the Rubber driver roller then the two screws that attach the bearing to the frame. Pull the shaft in the direction of the arrow [2].



6. Four holes are provided in the frame to allow access to the Allen screws that mount the brake to the frame. Remove the screws and then remove the brake.

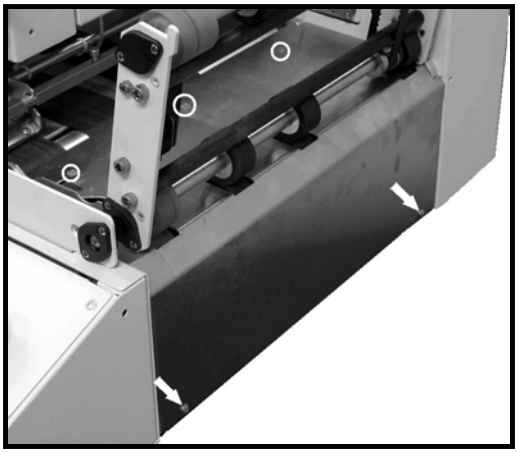


7. Reassemble in reverse order with the exception of installing the rubber roller last. Adjust the brake face plate. Then turn on the machine, set the speed control to "0" and press the Run button. Use the brake to hold the roller shaft while installing the sandpaper roller. Tighten the Allen screw.

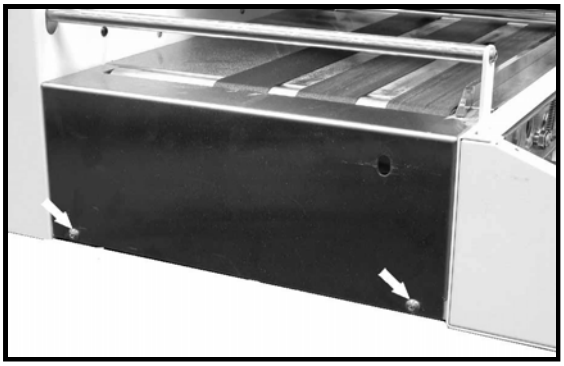
Replacing Transport Belts

1. Remove front and rear covers from tabber.
2. Remove the Reel assembly.
3. Remove the three screws that attach the cover to the exit roller assembly and remove the exit roller cover.

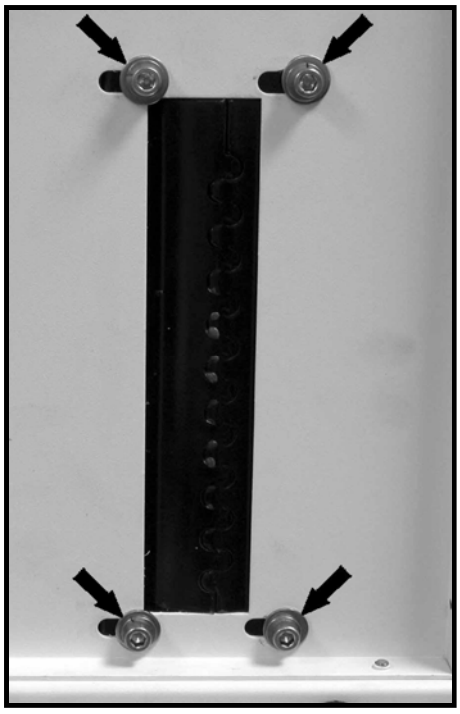
4. Remove the five screws that attach the right-hand cover and remove the cover.



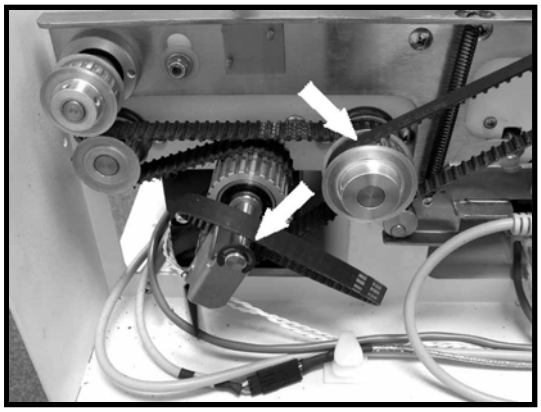
5. Remove the left-hand cover by removing the four screws (two screws on the inside of the side frame).



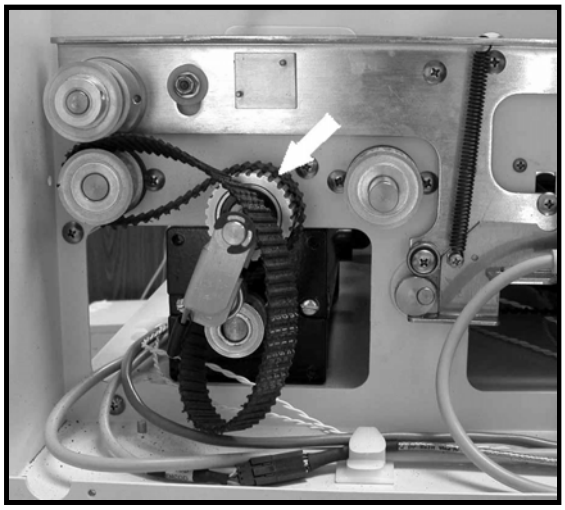
6. Position the tabber on its back and loosen the four screws that attach the motor. Slide the motor to the left. Return the tabber to its upright position.



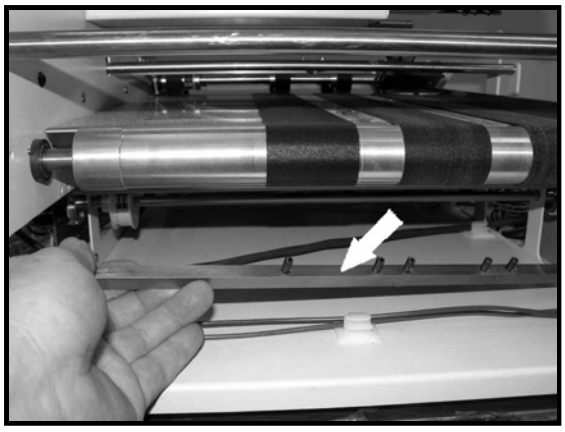
7. Release the tension spring and remove the exit roller drive belt. Then remove the pulley and belt from the tab drive mechanism.



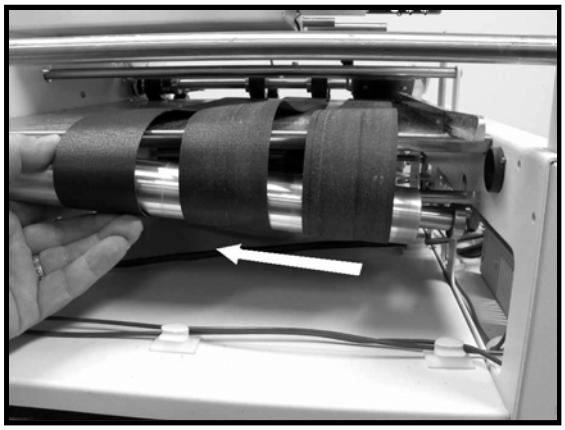
8. Remove the Main drive belt from the drive roller.



9. Remove the two screws on the non-operator side of the tabber and the single screw on the operator side of the tabber and then remove the belt guide assembly.

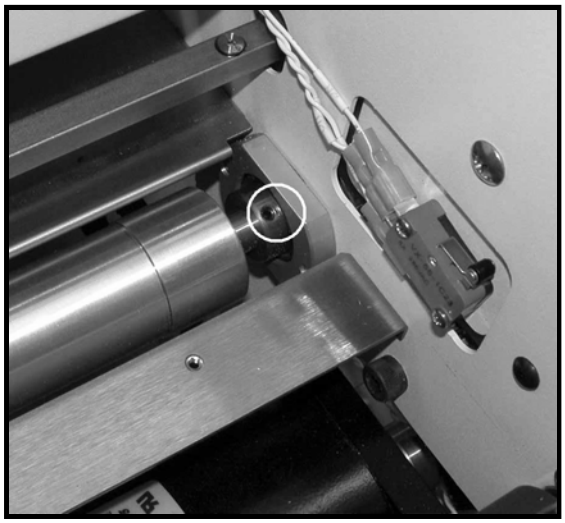


10. Remove the two screws on the non-operator side that attach the rear belt roller bearing to the frame. Slide the roller to the left to release it from the operator side bearing housing and remove the roller.

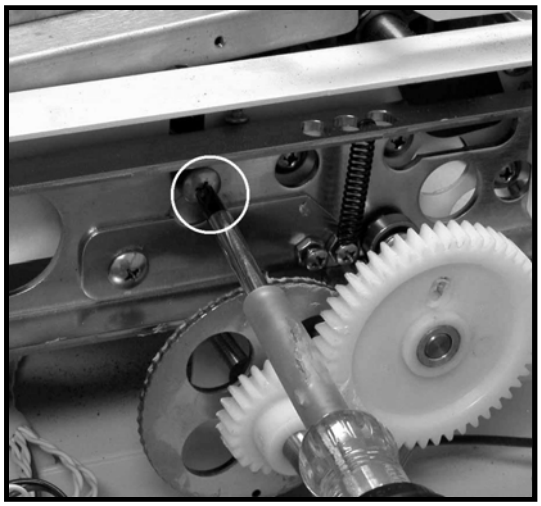


11. Remove the two screws that attach the tab sensor assembly to the machine and move the tab sensor out of the way.

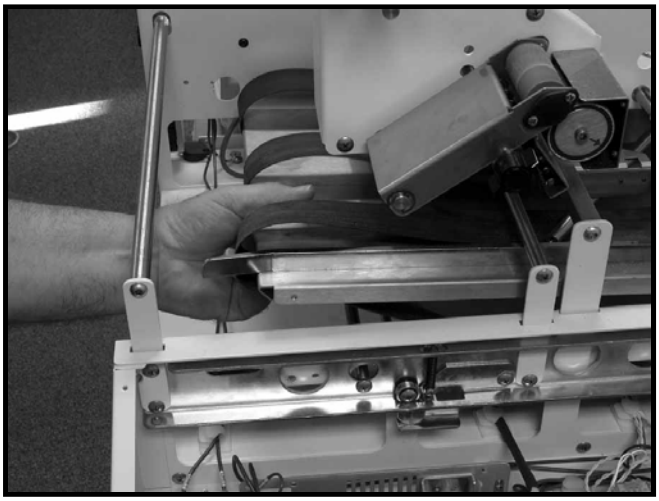
12. Loosen the Allen screw that holds the belt drive roller in place in the driver roller bearing housing. Grasp the pulley and pull the roller toward the rear of the machine so that the operator side end of the roller is released from the bearing housing.



13. A tie bar is located between the belts near the drive roller. Remove the two screws that attach it to the head frame and then remove this tie bar as shown.



14. The table is held in place by four screws. Remove the screws and lift the table so that it clears the operator side frame as shown.



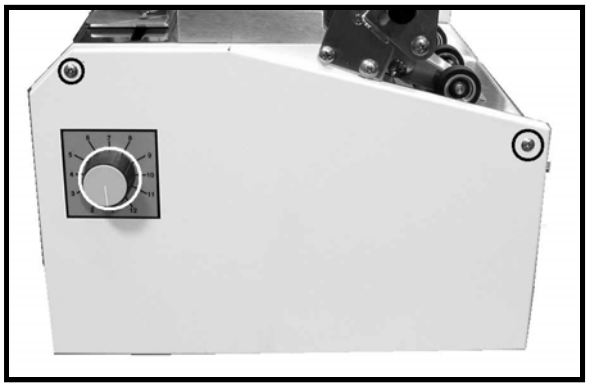
15. The belts can now be moved one at a time to the operator side of the machine and taken off.

16. Reassemble in reverse order.

Feeder Disassembly

Removing Covers

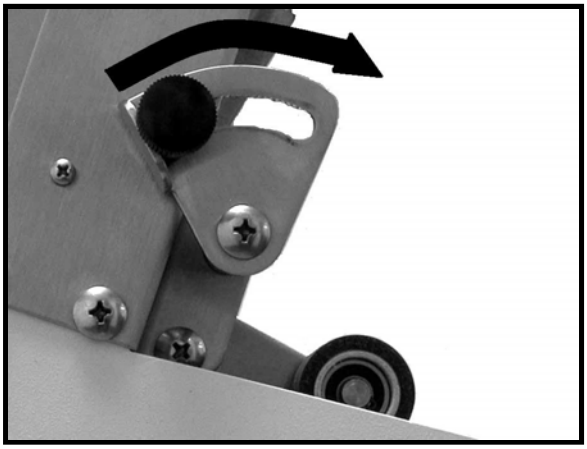
1. Unplug the feeder from it power source.
2. Remove the Speed Control Knob and the two screws circled from the operator's side of the feeder. Then lift the cover from the machine.



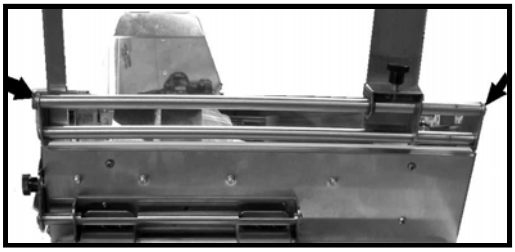
3. Remove the two screws circled from the non-operator's side of the feeder and lift the cover from the machine.

Replacing Feed Rollers

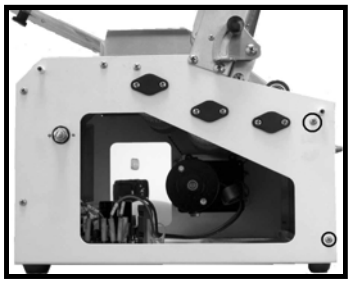
1. Remove Side covers from the machine.
2. Lock the upper forwarding rollers in the maximum open position by loosening the locking screw and rotating the lever clockwise, then tightening the locking screw.

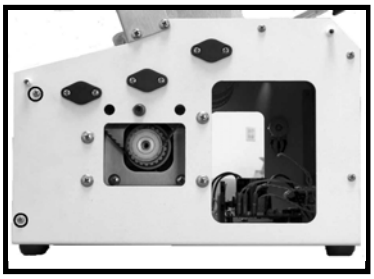


3. Remove the two screws that attach the side guide to the feeder and remove the side guide.



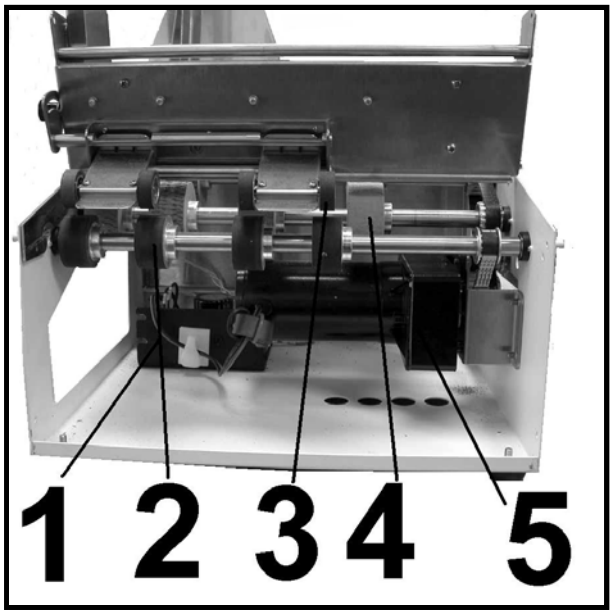
4. Remove the seven screws that attach the front plate to the feeder. There are two screws on each side and three across the top behind the feed roller.





5. Remove the bearings from each side of the roller shaft and remove the roller and shaft assembly from the machine. Replace the rollers and reassemble.

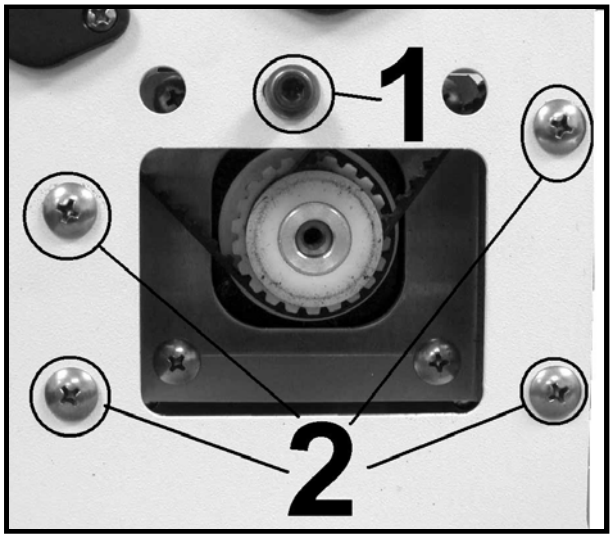
Feeder Front View



1. **Motor Speed Control**
2. **Lower Forwarding Rollers**
3. **Upper Forwarding Rollers**
4. **Feed Rollers**
5. **Feeder Main Drive Motor.**

Removing the Drive Motor

1. Unplug the feeder from its power source.
2. Remove the non-operator side cover.
3. Unplug the motor from the Motor Speed control PC Board.
4. Remove the Take-up Roller by removing the Allen screw [1].
5. Remove the four screws [2] that attach the motor to the feeder frame.



6. Reassemble in reverse order.

SECTION 6 – *Maintenance*

Cleaning

WARNING
THE TABBER AND FEEDER ARE PRECISION MACHINES THAT SHOULD BE CLEANED REGULARLY TO INSURE MANY YEARS OF SERVICE. BEFORE PERFORMING ANY MAINTENANCE, DISCONNECT THEM FROM THEIR POWER SOURCE!

The Tabber and Feeder must be cleaned regularly of accumulated paper dust and ink. Depending on the types of media that are run, paper dust may accumulate within machines and on the transport. Begin the cleaning process by unplugging both machines from their power receptacles and remove their covers.

The internal areas are best cleaned with a vacuum that has a soft brush attachment to help loosen the dust particles. Take care not to damage the PC Boards or electrical wiring.

The exterior of the machine may be cleaned with any standard household cleaner, which is non-abrasive and does not contain plastic harming solvents.

CAUTION
NEVER SPRAY OR POUR CLEANERS DIRECTLY ON OR INTO THE TABBER OR FEEDER. EXCESS LIQUID COULD HARM ELECTRONIC PARTS. ALWAYS DAMPEN A RAG WITH THE CLEANER AND APPLY IT TO THE PARTS TO BE CLEANED.

Rollers and Transport belts

The belts and rollers can become glazed with paper lint and ink from the media. They should be regularly cleaned with a mild abrasive household cleaner on a damp cloth.

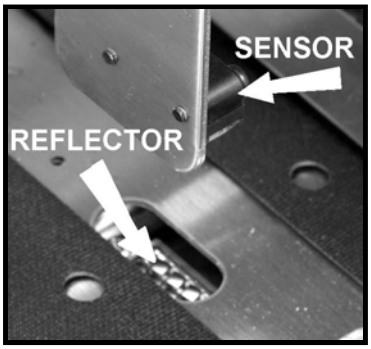
Avoid using solvents on the rubber rollers.

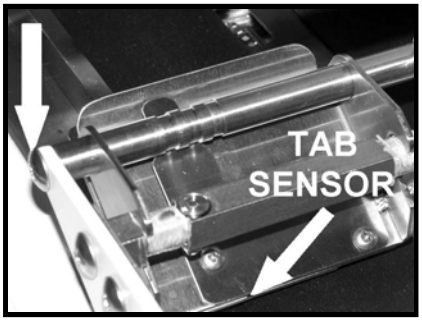
Cleaning the Sensors

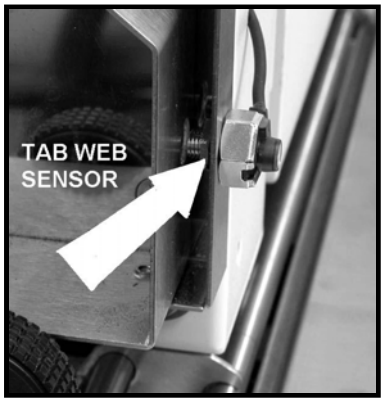
There are three sensors in the tabber; the media sensor located above the table of the tabber, the tab sensor on the applicator head and tab web sensor in the transport area. These sensors should be clean and free of accumulated paper dust. Use a vacuum with a soft brush attachment or dry compressed air to remove the dust.

WARNING
DO NOT USE ABRASIVES OF ANY KIND ON THE SENSOR LENS

The sensor locations are as follows:







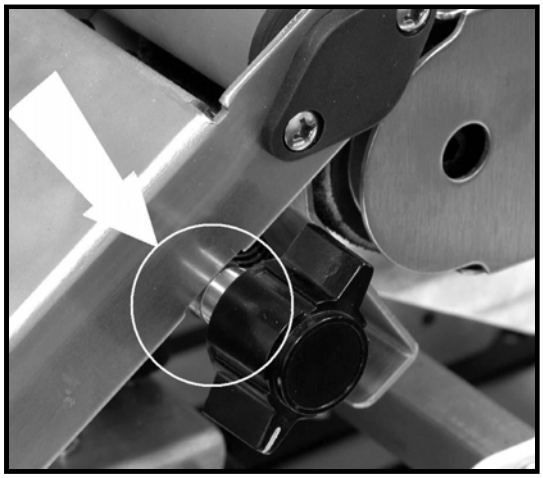
MEDIA SENSOR **TAB SENSOR** **TAB WEB SENSOR**

NOTE: For access to the Tab Sensor, remove the rear cover; loosen the screw on the Tab Sensor mounting shaft. Remove the screw shown and slide the sensor assembly off the mounting shaft. Disassemble the sensor assembly and clean with a Q-tip.

Lubrication

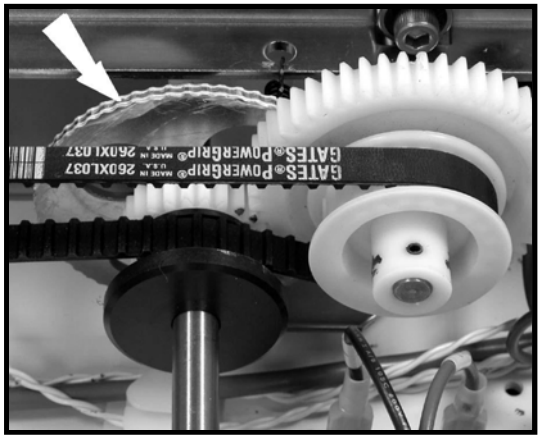
Several locations on the T-750 Tabber require regular lubrication. They are as follows:

1. Place a small amount of White Lithium Grease where the Drive Press Roller assembly touches the release cam.



2. Place a small amount of White Lithium Grease where the Unwind Drive Press Roller assembly touches the flat part of the release cam.

3. Lubricate the surface of the stepper cam for the head raise mechanism with white lithium grease as shown.



Notes

Appendix A - *Specifications*

Speed*	
Single Tab:	Up to 20,000 pieces per hour
Double Tab:	Up to 12,000 pieces per hour
Triple Tab:	Up to 8,000 pieces per hour (11” min. piece length)
Material size	
Minimum:	3” x 5”
Maximum:	13” x 17”
Material Thickness:	Up to 3/8”
Tab Size	
Minimum:	3/4” x 3/4”
Maximum:	1-1/2” x 1-1/2””
Roll Size:	Up to 16”” – 3” core
Number of Tabs:	1, 2, or 3
Tab Accuracy:	+/- 1/16”
Production Counters and Displays:	Life and Job Count and Production rate and speed
Error Reporting:	YES
Features:	Built-in Feeder (removable for in-line operation Can apply multiple stamps
Safety:	Interlocks on all adjustments
Dimensions:	25” W x 27” H (with reel) x 41” L (with feeder)
Weight:	90 lbs. (approximately)
Electrical:	115VAC 50/60Hz

Specifications are subject to change without notice.

*** NOTE: The maximum speed of the T-750 tabber is controlled by the software. The speed of the tabber for applying single tabs is 20,000 pieces per hour, for applying double tabs it is 12,000 pieces per hour and for applying triple tabs it is 8, 000 pieces per hour. Exceeding these speeds will cause the tabber to stop.**

NOTES

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03/14/2007
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